

Work Order ID 126997

126997

Page 1

Friday, January 23, 2015 1:15:59 PM

Item ID: D412-760-111 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 12/16/2014 Start Qty: 5.00 *5*

Required Date: 12/19/2014 Req'd Qty: 5.00 *5*

Reference: Cust Item ID: Customer: **REPRINT TO QC 21**

Approvals: Process Plan: WME Date: 5-1-23 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-760	G								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-760-111 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control	For test w/o								

DAS
86
309

JAN 23 2015

515101 23.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 126997***126997***

Page 2

Friday, January 23, 2015 1:15:59 PM

Item ID: D412-760-111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 12/16/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 12/19/2014 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-760-011

Location: _____

PPP Rev: _____

DAS
06
3-00

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

805/01/23

Could
Not find
O/Work order.
mrf
15-1-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Friday, January 23, 2015 1:10:06 PM

1 26997

D412-760-111

Required Date: 12/19/2014

Required Qty: 5.00

Comments: IPP Rev:A 11.04.19 per ecn10-646 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3933-1		Manufactured	No			110	Each	0.0000	DAS 06 ** 9-89	5			
D3933-1										126978.		MF 15-1-23	
Aft Wall Protector													
D3933-2		Manufactured	No			110	Each	0.0000	DAS 06 ** 9-89	5			
D3933-2										127001		MF 15-1-23	
Aft Wall Protector, RH													
D3935-1		Manufactured	No			110	Each	1.0000		1	5		
D3935-1									** DAS 06 9-89	126983		MF 15-1-23	
Pylon Wall Protector, LH													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST500			1						
				127293			1						
D3935-2		Manufactured	No			110	Each	1.0000		1	5		
D3935-2									** DAS 06 9-89				
Pylon Wall													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST500			1			126991.		MF 15-1-23	
				127294			1						
D3942-1		Manufactured	No			110	Each	90.0000		14	70		
D3942-1									** DAS 06 9-89				
Angle													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST068			90						
				127009			90						
										127009 x 31			
										96836 x 14		MF	
										126842 x 25		15-1-23	

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, January 23, 2015 1:10:06 PM

Page 2

Work Order ID: 126997

126997

Parent Item: D412-760-111

D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 12/16/2014

Required Date: 12/19/2014

Start Qty: 5.00

Required Qty: 5.00

D3942-3

Manufactured No

110

Each

66.0000

10

50

D3942-3

Clip

Location

Loc Qty

Loc Code

ST068

66

126977

22

128366

44

**

DAS

#3

9-89

126977 x 40

94910 x 10

MF 15-1-23

MS27039-4-10

Purchased No

110

Each

16.0000

20

20

MS27039-4-10

Screw

Location

Loc Qty

Loc Code

ST283

16

124552

16

DAS

**8

9-89

124552 x 20

MF 15-1-23

MS27039-4-14

Purchased No

110

Each

118.0000

6

30

MS27039-4-14

SCREW

Location

Loc Qty

Loc Code

CA

13

m129682

13

ST283

105

m131049

5

m131197

100

**

DAS

#5

9-89

m130716 MF

15-1-23

MS27039-5-08

Purchased No

110

Each

30.0000

6

30

MS27039-5-08

Screw

Location

Loc Qty

Loc Code

ST282

30

m131074

30

**

DAS

#3

9-89

m131074 v4

m124185 x 6

MF 15-1-23

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, January 23, 2015 1:10:06 PM

Page 3

Work Order ID: 126997

126997

Parent Item: D412-760-111

D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 12/16/2014

Required Date: 12/19/2014

Start Qty: 5.00

Required Qty: 5.00

MS27039-5-12

Purchased

No

110

Each

51.0000

8

40

MS27039-5-12

Screw

m/30783. enF
CS
9-59

Location

Loc Qty

Loc Code

ST282

51

124604

8

m131049

43

15-1-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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LOT TRACKING !!

Parent Item ID	Reason	Lot Qty	Lot Nbr	Lot Trans Date	Avg Cost Amt
D3933-1	126997	-5	126978	12/17/2014 11:44:06 AM	\$68.43
D3933-2	126997	-5	127001	12/17/2014 11:44:07 AM	\$80.22
D3935-1	126997	-5	126983	12/17/2014 11:44:07 AM	\$127.39
D3935-2	126997	-5	126991	12/17/2014 11:44:07 AM	\$113.50
D3942-1	126997	-31	127009	12/8/2014 1:29:18 PM	\$2.21
D3942-1	126997	-14	96836	12/5/2014 1:08:18 PM	\$2.21
D3942-1	126997	-25	126842	12/4/2014 7:42:08 AM	\$2.21
D3942-3	126997	-40	126977	12/5/2014 1:22:43 PM	\$2.13
D3942-3	126997	-10	94910	12/5/2014 1:08:18 PM	\$2.13
MS27039-4-10	126997	-20	124552	12/4/2014 7:42:08 AM	\$2.24
MS27039-4-14	126997	-30	m130716	12/4/2014 7:42:08 AM	\$2.22
MS27039-5-08	126997	-4	m131074	12/9/2014 1:32:07 PM	\$2.45
MS27039-5-08	126997	-6	124185	12/5/2014 1:00:02 PM	\$2.45
MS27039-5-08	126997	-20	124902	12/4/2014 7:42:08 AM	\$2.45
MS27039-5-12	126997	-40	m130783	12/4/2014 7:42:08 AM	\$1.07

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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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